



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14101W12-9-PO

Job Sheet 185107



Part No: RBE105-14101W12-9-PO

Job Qty: 1 ea

Part Name: Mounting Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE105-14101W12 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		11/16/18	0.00	0.00	Purchasing		DEC 12 2018
110	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging2		DEC 12 2018
120	QC	1 pcs		11/16/18	0.00	0.00	QC6		
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		11/16/18	0.00	0.00	QC21		DEC 12 2018

Part Op 100 - Issue P/O: _____ MANUFACTURE RBE105-14101W12-9 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-14101W12-9P	Mounting Base	1 Ea (1 ea)	100-Purchasing	S137076

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-14101W12-9P	1	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/22/18 3:47 PM dart.Lussier.Patrick

Container No: S137077



Part: RBE105-14101W12-9

Job No: 185107

Serial No/Batch: S137077

Revision: 1

Inspector:

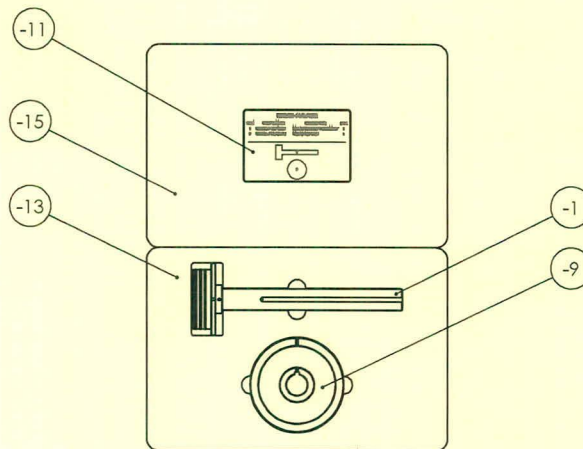
Exp Date:

Instructions:

Date: 12/12/18

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.			2/5/2016	DPD	JAG



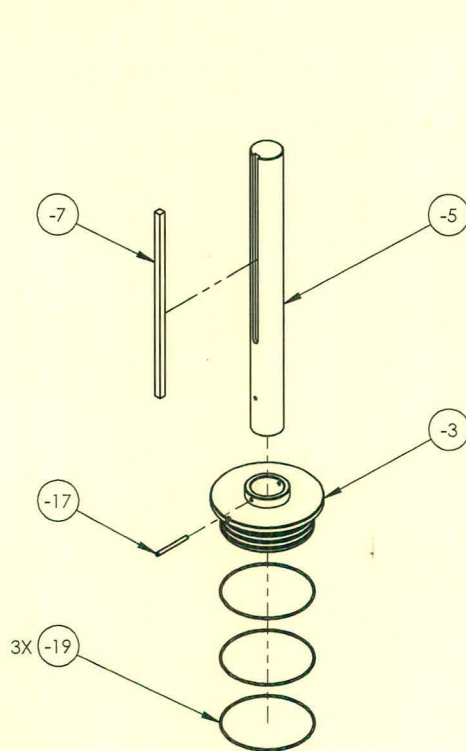
NOTE:
REF. EUROCOPTER T/N: 105-14101W12.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	MOUNTING SHAFT ASSEMBLY			2
	1		-3	1	MOUNTING SHAFT BASE	6061		3
	1		-5	1	MOUNTING SHAFT ROD	6061		4
	1		-7	1	KEY	S.S.	1/4 X 1/4 (MCMaster-CARR #92530A136) MODIFIED	5
			-9	1	MOUNTING BASE	6061		6
			-11	1	CONTENTS PLACARD	PLASTIC		7
		B/O	-13	1	BOTTOM FOAM	Y20, BLACK	4.25 X 11.40 X 17.00 (I.R. SPECIALTY)	8
		B/O	-15	1	TOP FOAM	Y20, BLACK	1.79 X 11.40 X 17.00 (I.R. SPECIALTY)	9
	1	B/O	-17	1	SPRING PIN	STEEL	Ø1/8 X 1-1/2 (MCMaster-CARR #98296A887)	2
	3	B/O	-19	1	O-RING	VITON	Ø.070 X Ø3.239 I.D. X Ø3.379 O.D. (MCMaster-CARR #9464K421)	2
		B/O	-21	1	CASE	PLASTIC	PELICAN #APP-1500-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
	ASSY -1							

		TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12		REV 1	
MAT'L REAT REAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .006 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125✓	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT		1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145	
SCALE 1:8		DATE 12/22/2015	
		SHEET 1 OF 9	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

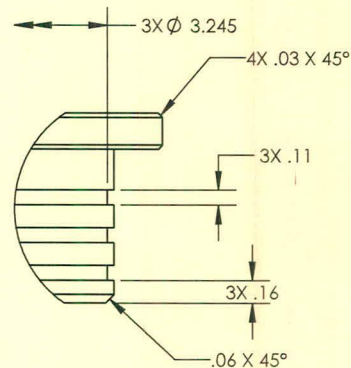
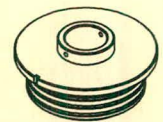
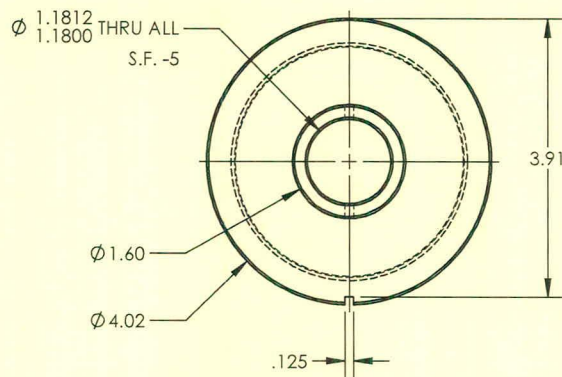


(1)
MOUNTING SHAFT ASSEMBLY

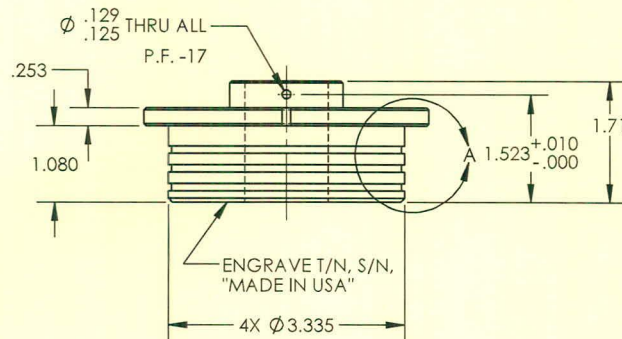
DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-1	REV 1
MAT'L HEAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .008 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.4M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:5	DATE 12/22/2015
SHEET 2 OF 9	

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DETAIL A
SCALE 1 : 1

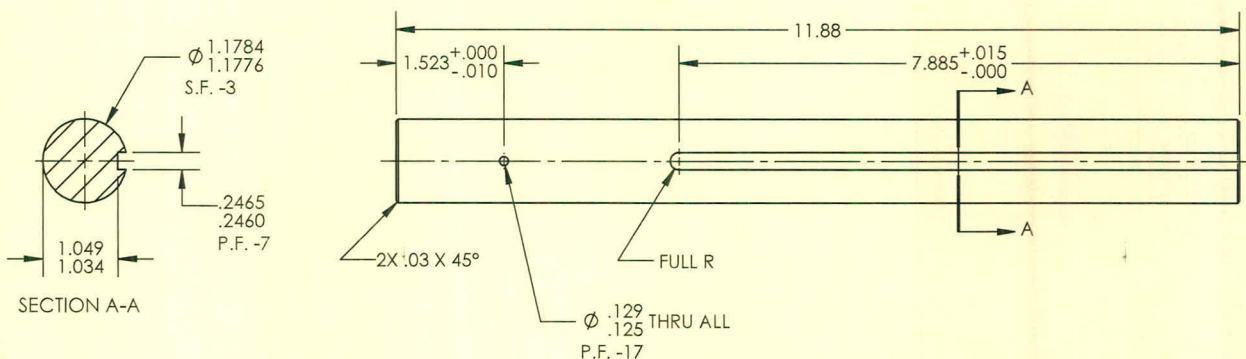
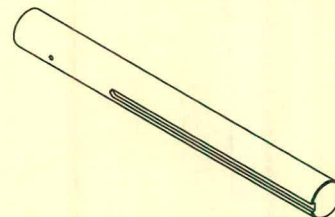


(-3)
MOUNTING SHAFT BASE

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-3	REV 1
MAT'L 6061 HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625, TYPE II, CLASS I DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125 ✓ 1. BREAK ALL SHARP EDGES .016 X 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145	
SCALE 1:2	DATE 12/22/2015
SHEET 3 OF 9	

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				APPROVED

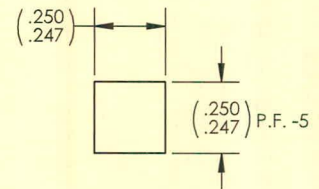
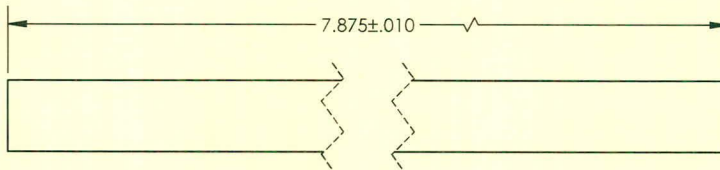
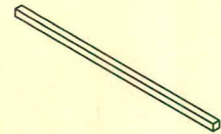


MOUNTING SHAFT ROD

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER
APPROVED: GILBERT	ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 12/22/2015	EC145
SHEET 4 OF 9	

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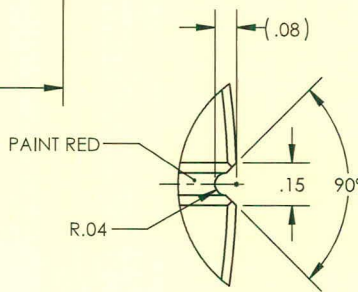
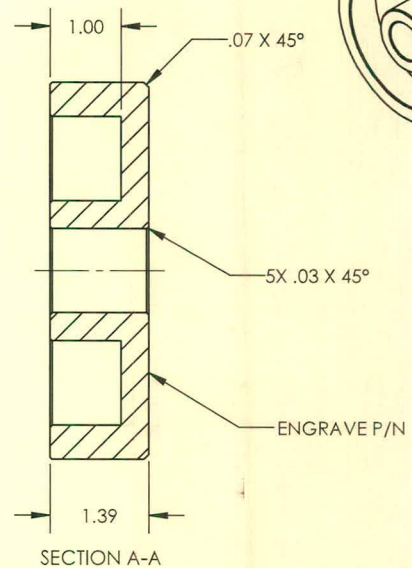
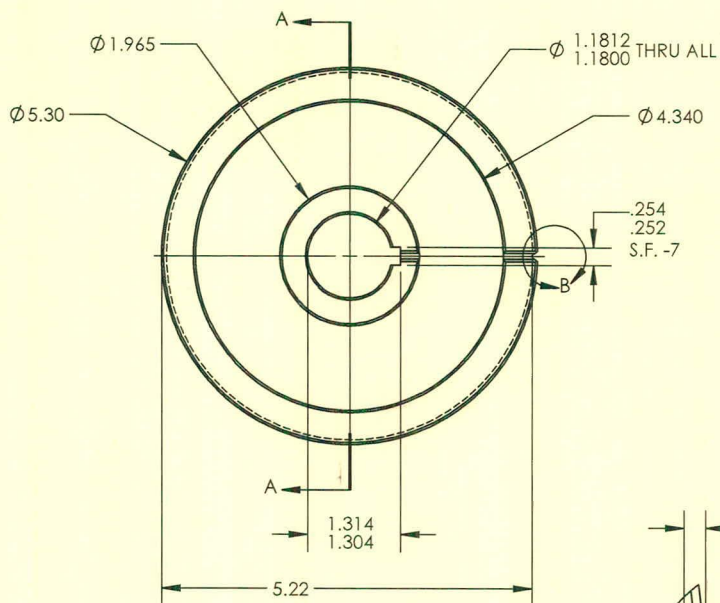
(-7)

KEY

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-7	REV 1
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .006 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 2:1	DATE 12/23/2015
	SHEET 5 OF 9

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



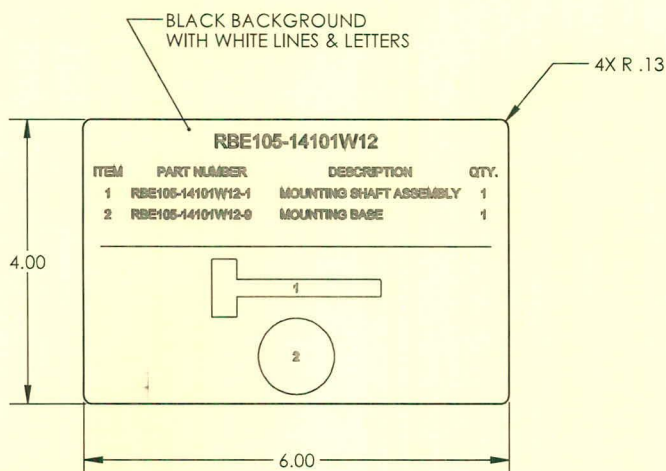
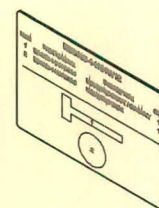
DETAIL B
SCALE 2:1
3 PLACES

(-9)
MOUNTING BASE

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-9	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS II	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER
QA APPR: LINDSAY	ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
	EC145
SCALE 1:2	DATE 12/22/2015
SHEET 6 OF 9	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:
USE PDF.



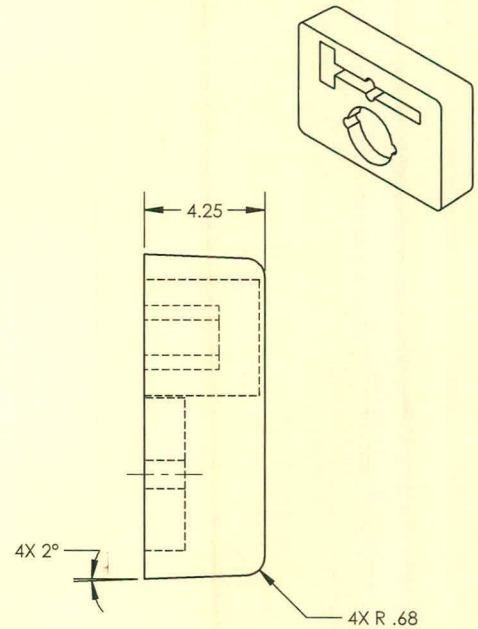
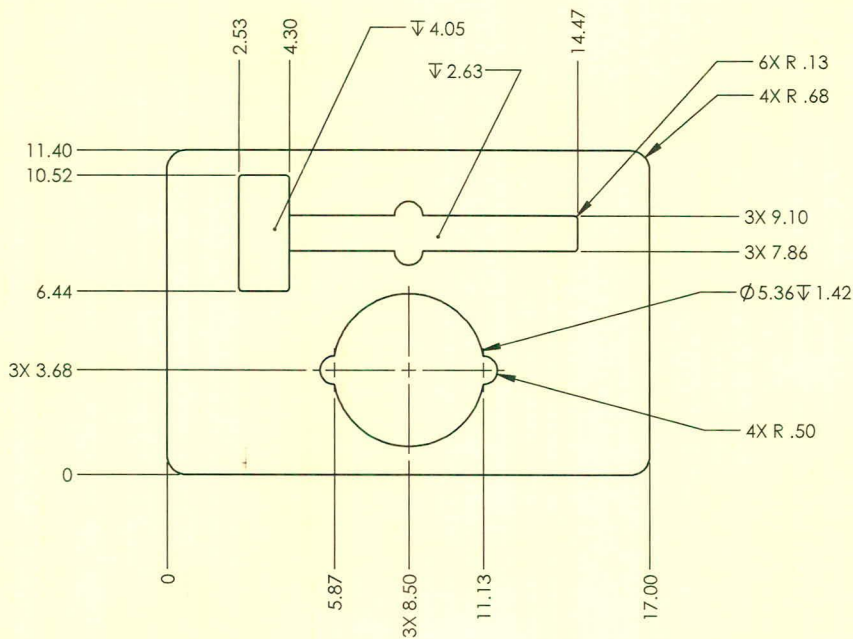
TITLE		MOUNTING DEVICE	
DWG NO.		RBE105-14101W12-11	
REV		1	
MAT'L PLASTIC		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
FINISH		FRACTIONS $\pm 1/8$	
SPEC		ANGLES $\pm 1^\circ$	
DRAWN BY: DUERFELDT		SURFACES = 125	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
SCALE 1:2		ASME Y14.6M-2009	
DATE 12/22/2015		USED ON MODEL	
SHEET 7 OF 9		EC145	

(-11)

CONTENTS PLACARD

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



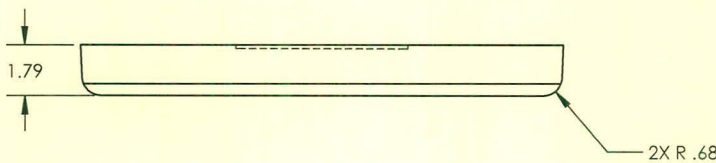
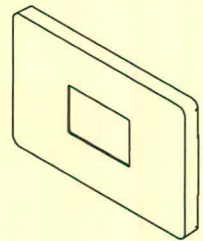
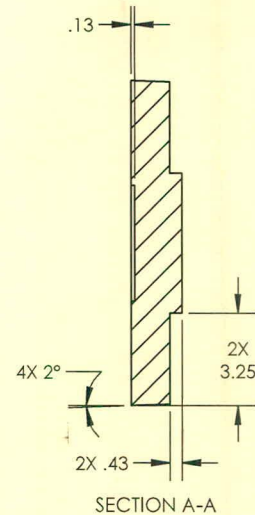
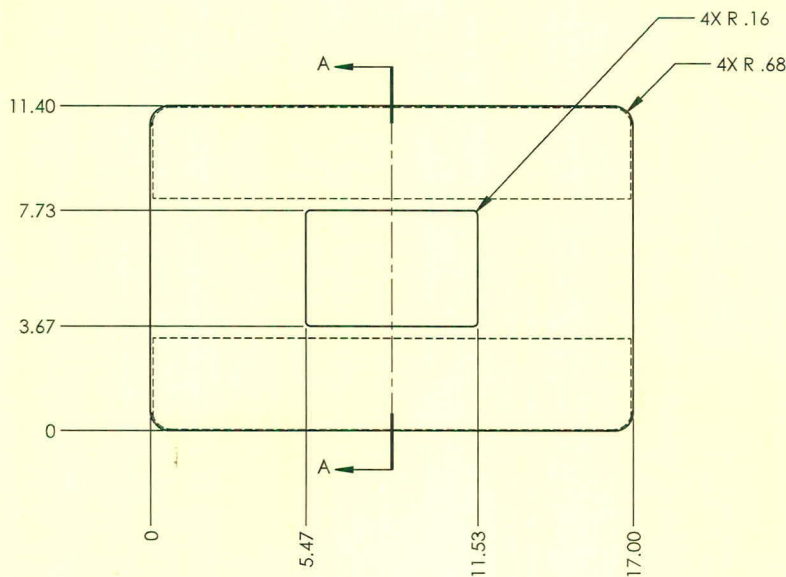
(-13)

BOTTOM FOAM

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-13	REV 1
MAT'L Y20, BLACK	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER
APPROVED: GILBERT	ASME Y14.5M-2009
SCALE 1:5	DATE 12/22/2015
	USED ON MODEL EC145
	SHEET 8 OF 9

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



(-15)
TOP FOAM

DART AEROSPACE	
TITLE MOUNTING DEVICE	
DWG NO. RBE105-14101W12-15	REV 1
MAT'L Y20, BLACK	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER
APPROVED: GILBERT	ASME Y14.5M-2009
SCALE 1:5	USED ON MODEL
DATE 12/22/2015	EC145
SHEET 9 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041411
PO Date: 10/22/18
Due Date: 12/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185055	RBE105-14101W2P			Outer Needle Bearings Extractor	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,100.00/Ea	\$4,100.00
Line Item Note REV 1													
2	185058	RBE105-14101W18P			Pressing-In Tool	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$1,950.00/Ea	\$1,950.00
Line Item Note REV 1													
3	185059	RBE105-45045W1P			Trammel	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,900.00/Ea	\$4,900.00
Line Item Note REV 1													
4	185061	RBE105W27P			Main Gear Box Hoisting Device	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
5	185063	RBE105-31501W6P			Puller	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$820.00/Ea	\$820.00
Line Item Note REV 1													
6	185064	RBE105-31702W24P			Tail Rotor Fork Shaft Check	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
7	185065	RBE105-13101W3P			Disassembly / Assembly - Rotating Control Rod	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$5,050.00/Ea	\$5,050.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185106	RBE105-14101W12-1P			Mounting Shaft Assembly	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
9	185107	RBE105-14101W12-9P			Mounting Base	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
Grand Total:												\$17,860.02	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 12/11/18 9:11 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24364
Shipment Date: 10-Dec-2018
Ship Via: our truck
Order Number: 3112
Order Date: 10/24/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041411
Terms: Net 60 Days

Quantity								
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
1	1	1 ✓	0	0	EA	DART-RBE105-14101W2P Extractor for Outer Needle Bearing	1	3112-01
2	1	1 ✓	0	0	EA	DART-RBE105-14101W18P Pressing - In Tool	1	3112-02
3	1	1 ✓	0	0	EA	DART-RBE105-45045W1P Trammel	1	3112-03
5	1	1 ✓	0	0	EA	DART-RBE105-31501W6P Puller	1	3112-05
7	1	1 ✓	0	0	EA	DART-RBE105-13101W3P Pitch Link Tool	1	3112-07
8	1	1 ✓	0	0	EA	DART-RBE105-14101W12-1P MOUNTING SHAFT ASSEMBLY	1	3112-08
9	1	1 ✓	0	0	EA	DART-RBE105-14101W12-9P MOUNTING BASE	1	3112-09

DAS
38
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24364
Shipment Date: 10-Dec-2018
Ship Via: our truck
Order Number: 3112
Order Date: 10/24/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041411 ✓
Terms: Net 60 Days

Quantity								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
1	1	1 ✓	0	0	EA	DART-RBE105-14101W2P Extractor for Outer Needle Bearing	1	3112-01
2	1	1 ✓	0	0	EA	DART-RBE105-14101W18P Pressing - In Tool	1	3112-02
3	1	1 ✓	0	0	EA	DART-RBE105-45045W1P Trammel	1	3112-03
5	1	1 ✓	0	0	EA	DART-RBE105-31501W6P Puller	1	3112-05
7	1	1 ✓	0	0	EA	DART-RBE105-13101W3P Pitch Link Tool	1	3112-07
8	1	1 ✓	0	0	EA	DART-RBE105-14101W12-1P MOUNTING SHAFT ASSEMBLY	1	3112-08
9	1	1 ✓	0	0	EA	DART-RBE105-14101W12-9P MOUNTING BASE	1	3112-09

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

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20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1 /	RBE105-14101W2P ✓	Outer Needle Bearings Extractor	1	PO041411 /
1 /	RBE105-14101W18P ✓	Pressing-In Tool	1	PO041411 /
1 /	RBE105-45045W1P ✓	Trammel	1	PO041411 /
1 /	RBE105-31501W6P ✓	Puller	1	PO041411 /
1 /	RBE105-13101W3P ✓	Pitch Link Tool	-	PO041411 /
1 /	RBE105-14101W12-1P ✓	Mounting Shaft	1	PO041411 /
1 /	RBE105-14101W12-9P ✓	Mounting Base	1	PO041411 /

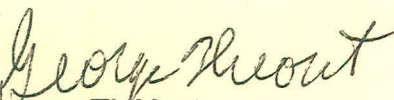
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No deviations for these part

Material supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Théoret

Vankleek Hill, December 10, 2018

